

**WHAT IS CLAIMED IS:**

1. A shoe comprising  
a molded rubber outsole;  
a molded midsole disposed within said outsole, said midsole being contoured to approximate the shape of the sole of a wearer's foot;  
an upper; and  
a foxing, said foxing being fused to said upper and said outsole along an interface therebetween by application of a vulcanization process permanently securing together said upper and said outsole.
2. The shoe of claim 1, wherein said upper and said outsole define a seam extending around said shoe at said interface, and said foxing is disposed around said shoe over said seam to contact said upper and said outsole across said interface.
3. The shoe of claim 1, wherein said outsole comprises a cored out shell defining a space for receiving said midsole.
4. The shoe of claim 1, wherein said upper comprises a base panel disposed adjacent said midsole and encasing said midsole within said outsole.
5. The shoe of claim 1 or claim 4, wherein said upper comprises a base panel configured to adopt the shape of a contoured midsole when formed around a contoured last.
6. The shoe of claim 1, wherein said midsole comprises a material relatively less dense than cured rubber.
7. The shoe of claim 6, wherein said outsole comprises rubber.
8. The shoe of claim 1 or claim 7, wherein said midsole comprises polyvinyl urethane.

9. The shoe of claim 1, wherein said upper comprises a base panel comprising a cradle cup heel.

10. The shoe of claim 1 or claim 9, wherein said upper comprises a base panel comprising a molded arch.

11. The shoe of claim 1, wherein said midsole comprises a cradle cup heel.

12. The shoe of claim 1, wherein said midsole comprises a molded arch.

13. The shoe of claim 1, wherein said upper comprises a sheet material selected from the group consisting of canvas and polyvinyl urethane.

14. The shoe of claim 1, wherein components of said upper are secured by stroebel stitching.

15. The shoe of claim 1, wherein said foxing material comprises uncured rubber.

16. The shoe of claim 1 or claim 15, wherein said foxing is in the form of a band.

17. The shoe of claim 1, further comprising an insole disposed over said base panel within said upper.

18. The shoe of claim 17, wherein said insole is removable from said shoe.

19. A method of forming a shoe, said method comprising the steps of:  
positioning a molded midsole within an outsole, the midsole being contoured to approximate the shape of a sole of a wearer's foot;  
with the midsole in place in the outsole, placing an upper over the midsole to form a seam between the upper and the outsole;

placing a foxing material around the shoe over the seam to contact the upper and the outsole across the seam; and  
vulcanizing the shoe to fuse the foxing material to the upper and the outsole.

20. The method of claim 19, wherein components of the upper are secured by stroebel stitching.
21. The method of claim 19, wherein the upper is formed by stretching about a last.
22. The method of claim 21, wherein the last is removed from the upper after the shoe is vulcanized.
23. The method of claim 21, wherein the last is contoured.
24. The method of claim 23, wherein the last includes a contoured bottom approximating the contours of the sole of a human foot.
25. The method of claim 19, comprising the further step of inserting a removable insole into the shoe after vulcanizing.
26. The method of claim 19, comprising the further step of molding the midsole to include a cradle heel cup and a molded arch.
27. A shoe comprising:
  - a molded rubber outsole defining an open area surrounded by a rim, the outsole being formed of a first material having a first density;
  - a molded midsole disposed within the open area of said outsole, said midsole being formed of a second material having relatively lower density than said first material;
  - an upper; and

a foxing, said foxing being fused to said upper and said outsole along an interface therebetween by application of a vulcanization process permanently securing together said upper and said outsole.

28. The shoe of claim 27, wherein said first material comprises rubber.

29. The shoe of claim 27 or claim 28, wherein said second material comprises polyvinyl urethane.

30. A shoe comprising:

a molded rubber outsole defining an open volume surrounded by a rim, said outsole being formed of a first material having a first density;

a molded midsole disposed within said open volume of said outsole, said midsole being formed of a second material having relatively lower density than said first material and being contoured to approximate the shape of the sole of a wearer's foot;

an upper having a base panel contoured to approximate the shape of the sole of the wearer's foot; and

a foxing material, the foxing material being fused to the upper and the outsole upon application of a vulcanization process to permanently secure the upper to the outsole.

31. The shoe of claim 30, further comprising a removable insole.

32. The shoe of claim 30 or claim 31, wherein said midsole comprises a cradle cup heel and a molded arch.